

Work Order ID 81488

March-14-12 4:21:49 PM

ASAP

81488

Page 1

Item ID: D3637-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 14/03/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/03/14

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3637 | Rev B |

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

B 12-3-20

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B 12-3-20

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W 12.03.22 (25)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 81488

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Page 2

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Item ID: D3637-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 14/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|-------------|--------|--------------|------------------|---------------|------------------|----------------|
| 130 *130* Brake NC Brake NC | NC BRAKE Memo Form as per Dwg D3637 | 0.00 0.00 | | | | (25) | | | |
| | | | SP 12/03/29 | | | | | | |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | counted (725) | | | |
| | | | Sc 12/13/21 | | | | | | |
| 150 *150* Small Fab Small Fab | Small Fab Memo 1- drill holes as per dwg using DT89792- c'sink holes as per dwg3-deburr | 0.00 0.00 | | | | (21) | FF | 12-03-02 | PTO |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: D3637-3 PAR #: _____ Fault Category: Small FAB NCR: Yes No DQA: OK Date: 12/04/09
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/4/10

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) $48.45 \times 4 = 193.80$ | | | | | | |
|----------|------|--|-----------------------------|---------------------------------------|----------------|---------------------------|-------------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 12/04/02 | 150 | Countersink were made on 4 piece on the wrong side. Mis-read the drawing. F-C LOT didn't read Aug. | S 12/04/02 Q57042 | Scrub + do key No replace dt x4 | S 12/04/02 | S 12/04/02 | S Q57042 12/04/02 | S 12/04/02 |
| | | - Draw is clear + Instructions are clear. | S 12/04/11 Q57042 | | | | S 12/04/11 Q57042 | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 81488


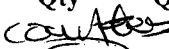
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81488

Page 3

Item ID: D3637-3 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 14/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|------------|--------------|---|---------------|------------------|----------------|
| 160 *160* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo  | 0.00 0.00 | | 5/12/04/02 | |  (x21) | | | |
| 170 *170* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 21 | 12/11/02 | | |
| 180 *180* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 21 | 12/11/02 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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 Required Date: 23/03/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 | Identify as per dwg & Stock Location: <u>245A</u> | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 200 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/04/03

12/4/3

1204-3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

March-14-12 4:21:53 PM

Page 1

Work Order ID: 81488

81488

Parent Item: D3637-3

D3637-3

Parent Item Name: Bracket

Start Date: 14/03/2012

Required Date: 23/03/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M2024T3S.050 | | Purchased | No | | | 100 | sf | 33.9000 | 0.134 | 2.256842 | | | |

M2024T3S 050

**

B12-3-20

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

33.9

117684

33.9

117684

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

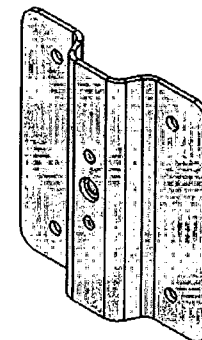
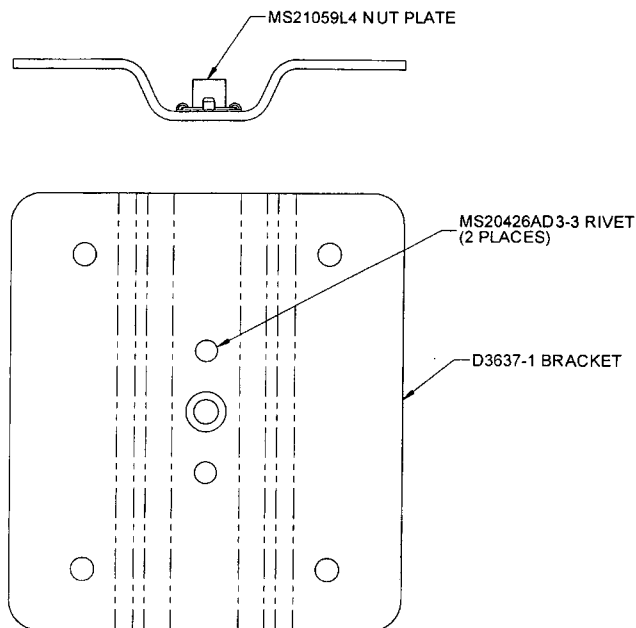
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 81488 MJS
12/03/14

RELEASED
12-26-2015

D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

D3637-041 PARTS:

| QTY | P/N | DESCRIPTION |
|-----|--------------|------------------|
| X | D3637-041 | BRACKET ASSEMBLY |
| 1 | D3637-1 | BRACKET |
| 1 | MS21059L4 | NUTPLATE |
| 2 | MS20426AD3-3 | RIVET |

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

| | | | |
|------------|---|--|--------------|
| B | FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE | LE | 07.12.18 |
| A | NEW ISSUE: REPLACES G10608, G10602 & G10609 | LE | 07.07.27 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | LE | | |
| CHECKED | HE | DRAWING NO. | REV. B |
| MFG. APPR. | EP | D3637 | SHEET 1 OF 3 |
| APPROVED | EP | TITLE | SCALE |
| DE APPR. | EP | BRACKET | 1:1 |
| DATE | 07.12.18 | COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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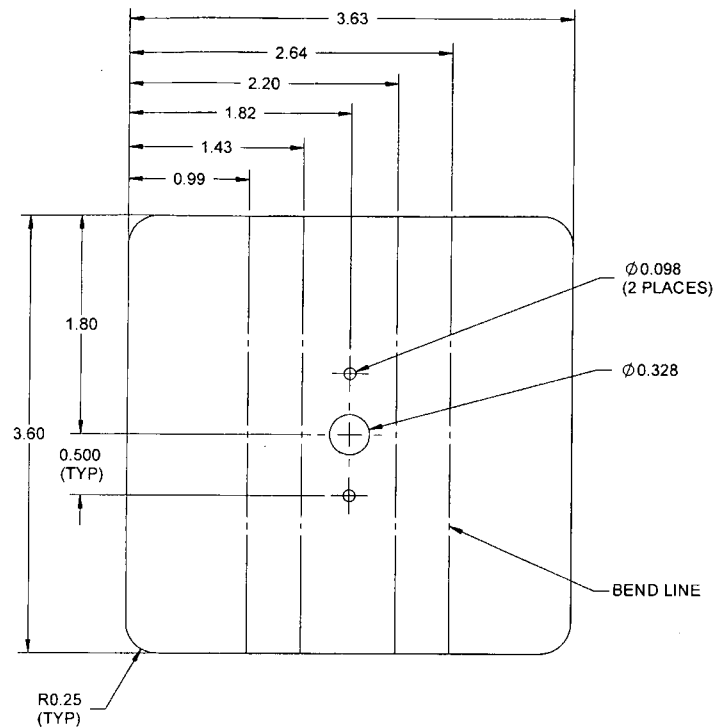
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

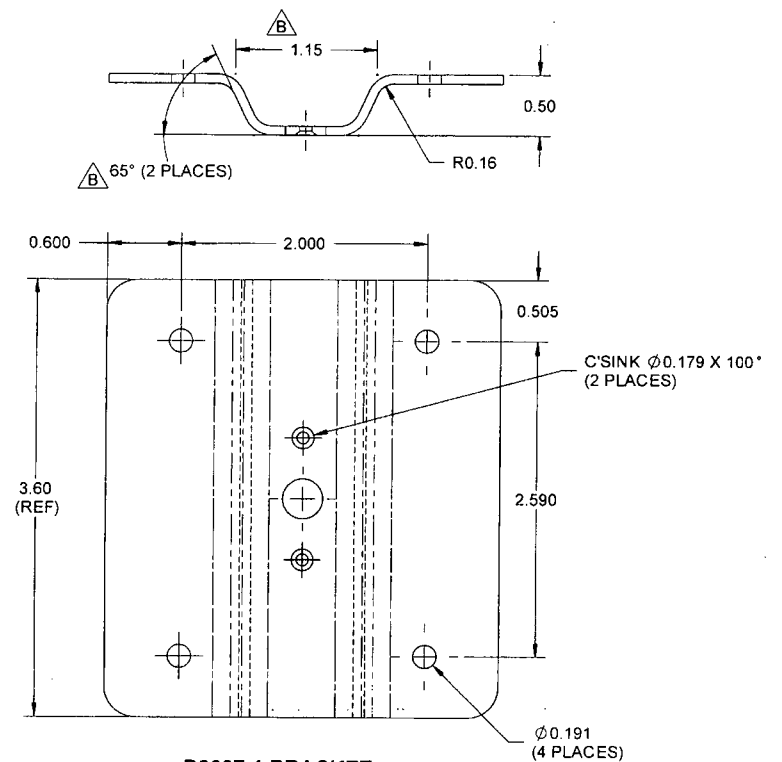
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NOTE: Date & initial all entries

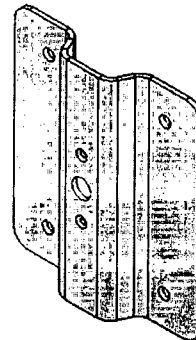
81488



D3637-1F FLAT PATTERN



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)



D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

| | | | |
|--|----------|--|--------------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | LE | DRAWING NO. | REV. B |
| MFG. APPR. | LE | D3637 | SHEET 2 OF 3 |
| APPROVED | LE | TITLE | SCALE |
| DE APPR. | LE | BRACKET | 1:1 |
| DATE | 07.12.18 | COPYRIGHT © 2007 BY DART AEROSPACE LTD | |
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08-2-05 11:40

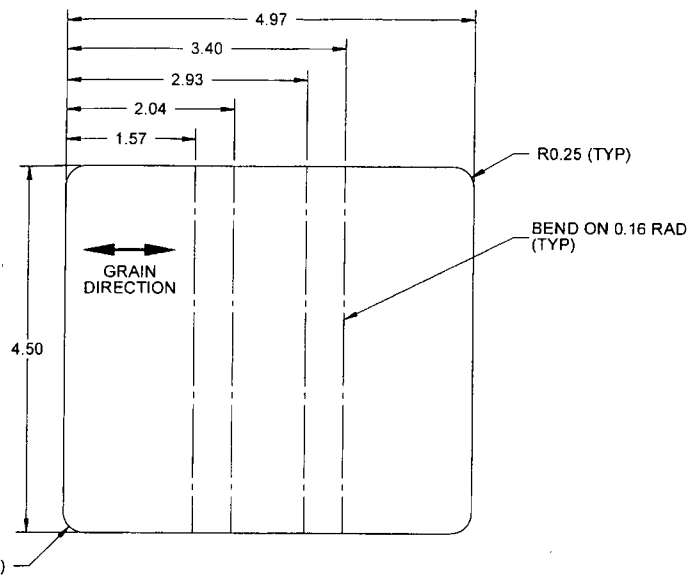
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

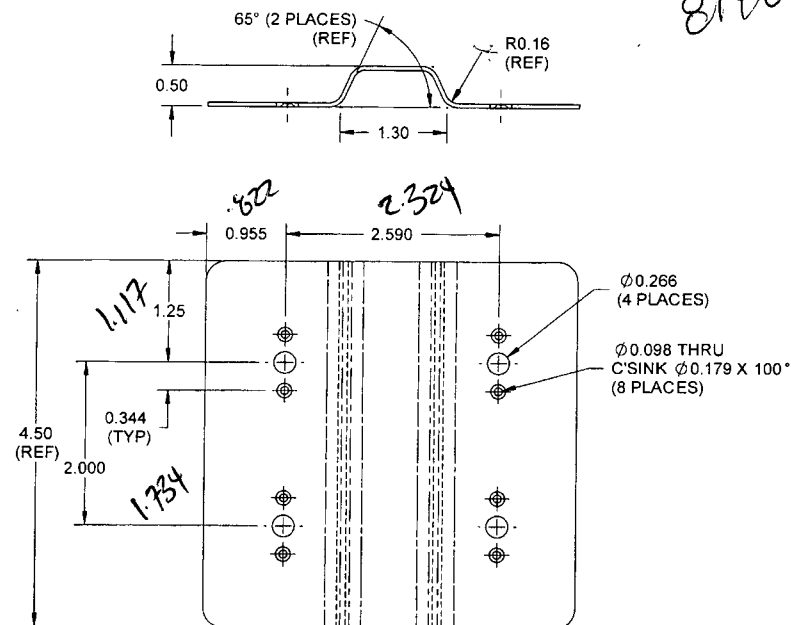
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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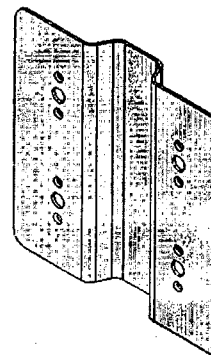
NOTE: Date & initial all entries



D3637-3F FLAT PATTERN



D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)



D3637-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.32 lbs

| | | | |
|---|----------|-----------------------------|--------------|
| DESIGN | TS | DART AEROSPACE LTD | |
| DRAWN | LE | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | Ref | DRAWING NO. | REV. B |
| MFG. APPR. | Ref | D3637 | SHEET 3 OF 3 |
| APPROVED | NA | TITLE | SCALE |
| DE APPR. | Ref | BRACKET | 2:3 |
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| DATE | 07.12.18 | | |

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